95537

Page 1

January-11-13	8:36:05 AM			90:	7.5/			. 1				Page 1	
Item ID: Revision ID:	D3945-041			Accept	*N900	040	100) *	Setup S		ı VI.	S1*	
Item Name: Start Date: Required Date: Reference:	Bracket 1/11/13 1/25/13	Start Qty: 24. Req'd Qty: 24.	/ -	=	Cust Item Customer:					Stop	*N:	S2*	
Approvals:	Process Pla	an: <u>Mし</u> ゴ	Date: 13-01	-1 Tooling:	D	ate:				Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:			S	Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec		Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr											
D3945	A		1				•						
100			,	0.00									
100 Waterjet FLOW CNC Waterj	at.	Memo	D 2045 1	0.00				24		· 		Jm13-2	-17
606 . Os		Dwg Re	s per Dwg D3945-1 ev: A										
		2-Debu	rr if necessary										
110		QC2- Inspect parts of	off machine FAI/FAIB	0.00		*3						,2	
110 QC Quality Control		Memo		2.00			•	_24	<u>, </u>		,4	Jm 13-2-1	2

NCR:	Yes /	No

WORK ORDER NON-CONFORMANCE / UPDATE

	DQA:	Date:	
(QA Closed:	Date:	
DEP	ARTMENT	PROCESS	
		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	Sign & Date	Verification	QC Inspector

						I	_				QA Closea:	Date		
Work Orde	er:					DISPOSITION				AGAINST DE	DEPARTMENT/PROCESS			
	-				,	Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.		Engineering Quality	
						Use-as-is	-		noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR 1	No.			· · · · · · · · · · · · · · · · · · ·	<u> </u>	Work Order Update		Large Fab Composite]	Supplier		
			,											
Root	- 1				· ·	ption of work order update	In	Initial Action			Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Chie	nief Eng Description			Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process	Ш													
Supplier	Ш													
Training	Ц													
Unapproved				! !										
						F.A.	AULT	CATE	GCIRY					
Landi	ng G	ear				General					_		_	
	-	Bending		_		Bend		Grain		L	Ovalized		Pressure/Forced	
	Ш	Centre No	ot Concer	ntric to	0/s	BOM/Route	╚	Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Ш	Cracks				Broken/Damaged		nspecti	or Incomplete		Part Incorred	ct	Weld	
		Crushed/0	Crimped.			Burrs		nstruct	ions Incomplete/U	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs					Contamination	Ц١	Mainte	nance		Part Moved			
	Heat Treat					Countersink		Mislabe	led		Positioned V	Vrong	_	
Inspection Strip in Tube						Cut Too Short		Misreac	ſ		Power Loss/	Surge	Other	
Ripples in Bend						Drill Holes		Offset						
Torque Waves in Extrusion					า [_	Drawing		Out of C	Calibration					
Turning Sequence						Finish	Out of Sequence							
Wave/Twist in Tube						Folio	Outside Dimensions							

Brake NC

Bend as per Dwg

January-11-13 8:36:05 AM Item ID: D3945-041 Accept *N900040100* Setup Start Revision ID: Item Name: Bracket **Start Date:** Start Oty: 24.00 1/11/13 Cust Item ID: Required Date: 1/25/13 Rea'd Otv: 24.00 **Customer:** Reference: Run Start Process Plan: Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Run Hours Otv Code Qty Number Stamp 120 QC8- Inspect parts - second check 0.00 *120* Memo **Quality Control** 130 0.00 *120* Small Fab 0.00 Memo Small Fab COUNTERSINK AS PER DWG 140 0.00 *140* Brake NC 0.00 Memo

				DQA:	Date:
ICR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

					w				QA Closed:	Date	
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part N					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other	
Root				Descri	ption of work order update	Initia	П	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	· 1			Date	Verification	QC Inspector
Doc/Data				-		<u> </u>		•	1		
Equip/Tooling						ļ					
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
					F	AULT CA	TEGORY				
Landii	ng Gear				General				_		_
	Bendin	-			Bend	Grai	n		Ovalized		Pressure/Forced
	—	Not Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped	-	<u> </u>	Burrs	Instr	uctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance		Part Moved		
	Heat Treat				Countersink	Misl	abeled		Positioned \	Wrong	-
	Inspection Strip in Tube			<u> </u> _	Cut Too Short	Misr			Power Loss/	'Surge	Other
	Ripples in Bend			Drill Holes	Offse						
	_	Waves in I		n	Drawing	_	of Calibration				
Turning Sequence					Finish	Out of Sequence					
	Wave/Twist in Tube				Folio	Outside Dimensions					

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Insp.

January-11-13 8:36:05 AM Item ID: D3945-041 Accept *N900040100* Setup Start Revision ID: Item Name: Bracket Start Date: **Start Oty: 24.00** 1/11/13 Cust Item ID: Required Date: 1/25/13 Reg'd Otv: 24.00 **Customer:** Reference: Run Process Plan: _____ Date: ____ Approvals: Tooling: Date: Stop ____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Un/ Tool ID Tool # Plan Reject Accept Reject Work Center ID Description Run Hours Qty Number Stamp Code Otv 150 QC5- Inspect part completeness to step on W/O 0.00 *150* Memo **Ouality Control** 160 Chemical Conversion Coat per OSI005 4.1 0.00 *160* HandFinish 0.00 Memo Hand Finishing

170

170

Quality Control

Memo

QC3- Inspect Part Finish

0.00

0.00

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			-
											QA Closed:	Date	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstub Machining Small Fa Thermoforming Finishin Large Fab Composit				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update	1	Initial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Daţa Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					·			·	·				
						F	ΑUI	LT CATE	GCIRY				
Landi	ng G	iear				General		-		_	_	-	-
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube				D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend			Drill Holes	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Quality Control

Memo

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January-11-13 8:36:05 AM Item ID: D3945-041 Accept *N900040100* Setup Start Revision ID: Item Name: Bracket **Start Date:** *24* 1/11/13 **Start Oty: 24.00 Cust Item ID:** Required Date: 1/25/13 Rea'd Otv: 24.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Reject Set Up/ Tool ID Tool # Plan Reject Accept Insp. Work Center ID Description Run Hours Otv Number Code Oty Stamp 180 Pick Kit 0.00 *120* Packaging 0.00 Memo Packaging 190 0.00 *190* Small Fab 0.00 Memo Small Fab INSTALL NUT PLATES AS PER DWG 200 QC5- Inspect part completeness to step on W/O *200* 0.00 /3 2 2/

									DQ/1.			
NCR: Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / U	PDATE	QA Closed:	Date:		
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		_
					Rework		Skid-tube	Crosstube]	Water Jet	Engineering	_
Part No.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR No.					Work Order Update		Large Fab	Composite]	Supplier] [
	r ·	· · · · · · · · · · · · · · · · · · ·							· .	· · · · · · · · · · · · · · · · · · ·		
Root					ption of work order update	Initial	Δ	action	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	g Des	scription	Date	Verification	QC Inspect	or
Doc/Data												
Equip/Tooling												

DOA

Date.

FAULT CATEGORY Landing Gear General Bend Bending Grain Pressure/Forced Ovalized Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Weld Part Incorrect Crushed/Crimped. Instructions Incomplete/Unclear Wrong Stock Pulled Burrs Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Other Cut Too Short Misread Power Loss/Surge Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration **Turning Sequence** Out of Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

Operator Material Setup Other Process Supplier Training Unapproved

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January-11-13 8:36:05 AM Item ID: D3945-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bracket **Start Date:** 1/11/13 **Start Oty: 24.00 Cust Item ID:** Required Date: 1/25/13 Req'd Otv: 24.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Oty Number Stamp Identify as per dwg & Stock Location: 210 *210* Packaging 0.00 Memo Packaging

220

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

								*			QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	۱٥.					Rework Scrap Use-as-is Work Order Update	Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging						
Root					Descri	ption of work order update	Ir	nitial	Ac	ction	Sign &		
Cause						Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator]									:		
Material													
Setup]		1						
Other `			:				-						
Process		1	1										
Supplier			1									-	
Training							1						
Unapproved			<u> </u>				<u> </u>					<u>L</u>	
ļ							AUL	CATE	GORY				
Landi	_	7			_	General		C i				<u></u>	70
		Bending			o/s	Bend BOAA/Bourts	-	Grain		<u> </u>	Ovalized	+=1===================================	Pressure/Forced Temperature/Cure
	⊢	Centre No Cracks	ot Concei	ntric to	U/S -	BOM/Route Broken/Damaged	\vdash	Hardwa	ire iori Incomplete	<u> </u>	Over/Under Part Incorre	-	Weld
		4	Crimnad		-	-1 · · · · · · · · · · · · · · · · · · ·	-	•	ion incomplete ions Incomplete,	/Unclear	Part Lost/M		Wrong Stock Pulled
	Crushed/Crimped. Burrs				-1	-		nance	Officieal	Part Moved	1551118		
	Cuffs Contamination Heat Treat Countersink					Countersink	-	Mislabe		-	Positioned V	Mrong	
	<u></u>					Cut Too Short	\vdash	Misread			Power Loss/		Other
	Ripples in Bend Drill Holes					\vdash	Offset	-	L	1. 0 2033/			
Torque Waves in Extrusion Drawing					Out of Calibration								
Turning Sequence Finish					Out of Sequence								
	Wave/Twist in Tube Folio					-		Dimensions					

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Picklist Print

January-11-13 8:36:09 AM

Work Order ID: 95537

Parent Item:

D3945-041

Parent Item Name: Bracket

95537

D3945-041

Start Date: 1/11/13

Required Date: 1/25/13

Start Qty: 24.00

Required Qty: 24.00

	IPP RevA: New issu	ue DD verified b	y:EC		¥						•		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050 *M6061T6 .050 Sheet	6S 050*	Purchased	No			100	sf	491.5120	0.0118	0.298105 8.3			Jm13-2-12
3001 TO .030 Sheet				Location	<u>n</u>	Loc	<u>Qty</u>	Loc Code			•		
				MAT021	1	491	1.512	-					
					114799		5.682						
					114993		27						
					121192		14.35	•	_				
		•			123293	29	93.48		1	93983			
MS21059L3		Purchased	No			180	Each	23.0000	1	24	//		
MS2105!	91 3								**		0(3/	<u> 2/2</u>	<i>5</i>
. Vac 7 late				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code			<i>!</i>		
		*		ST316			23				19/	1788	37 (80c
					121444		15 -		_		MIE	24291	1
145204244702		•			123900		8		17	_5_	, , ,	(* ')	
MS20426AD3-3		Purchased	No			180	Each	7,563.000	2	48	17/	/ /	/ /
MS2042	6AD3-3	· !						r	**		<i>5</i> /2/	3/0	20_
•				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code			,		
				GA			493						
		r			122814		493		_	46			
				ST316			699		_				
					119109		282		_				
					19099		417		_				
				ST333			6371		_				
					121011		121		_				
					123352		6250		_				

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											DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UP	DATE				
								T			QA Closed:	Date:		
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
l Work Gra	-					Rework			Skid-tube Crosstube			Water Jet	Engineering	
Part I	No.] ' '				Small Fab	Prod. Eng. Coor. Quality			
						Use-as-is	├ ─┤ │			Finishing	Rec/Sto	re/Packaging	Other	
NCR I	No.					Work Order Update		i	Large Fab	Composite	_	Supplier		
<u></u>			ı	•				L			T c: o	T	T	
Root		. .	.			ption of work order update	- 1	Initial		tion	Sign &	, r	061	
Cause	_	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data	Ш						ļ							
Equip/Tooling											1			
Operator														
Material														
Setup				, ,										
Other	П													
Process	П													
Supplier	П													
Training	П													
Unapproved														
							FAU	LT CATE	GORY					
Landi	ing G	iear				General								
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
-	Centre Not Concentric to O/S					——				Over/Under	tolerance	Temperature/Cure		

Inspection Incomplete

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish Folio

Burrs

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	95537
Description: Bracket	Part Number:	D3945-1
Inspection Dwg: D3945 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing		Actual			Method of		
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments	
Ø0.098	+0.004/-0.001	0.098"	-		U s	Trmoi	
Ø0.250	+0.005/-0.001	0.250	-		V		
0.250	+/-0.010	0.249"	_		٧		
1.250	+/-0.010	1.ダミダ,	_		V	-	
0.625	+/-0.010	O. Ggy"	-		V	-	
1.359	+/-0.010	1.358"	_		V	•	
0.344	+/-0.010	6.347"	_		V		
0.688	+/-0.010	0.692	_		V		
0.050	+/-0.010	0,047"	-		V		
				·			
						· · · · · · · · · · · · · · · · · · ·	

Measured by: Jm	Audited by: SW3	Prototype Approval:	N/A
Date: 13-2-12	Date: 13.1.10	Date:	N/A ···

Rev	Date	Change		Rev	isec	hby	Approved
Α	09.07.29	New Issue	P/O D3945-041	KJ	d.	F)K
					7	/	

PARTS LIST

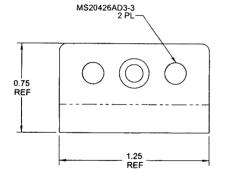
D

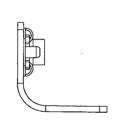
С

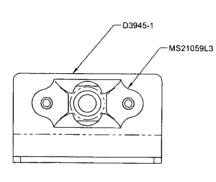
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3945-041	BRACKET
2	1	D3945-1	BRACKET
3	1	MS21059L3	NUTPLATE
4	2	MS20426AD3-3	RIVET

SHOPENRY REHERO W ENGINEERL (G UNCONTROLLED COPY SUBJECT TO A DESIGNATION WITHOUT WATTE

WORK ORDER A MUS NO. 95537 MUS 13-01-11







D

D3945-041 BRACKET

NOTES:

1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3945-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.01 lbs

Α NEW ISSUE 09.05.01 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3945 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE DE APPR. **BRACKET** NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD

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